

Work Order ID 132324

Thursday, May 07, 2015 9:01:33 AM

132324

Page 1

Item ID: D3537-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Wearpad

Stop ***NS2***

Start Date: 5/7/2015 Start Qty: 60.00

60

Cust Item ID:

Required Date: 5/7/2015 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: MCJ Date: MAY 07 2015 Tooling: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	D								
110	FLOW WATER JET	0.00							
110									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D3537-1 as per Dwg D3537								
	Dwg Rev: <u>D</u>								
	Prog Rev: <u>D</u>								
	2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

(60)

05/05/07

(60)

05/05/07

Thursday, May 07, 2015 9:01:33 AM

132324

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Wearpad

Start Date: 5/7/2015 **Start Qty:** 60.00 ***60***

Cust Item ID:

Required Date: 5/7/2015 **Req'd Qty:** 60.00 ***60***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

160

Weld per dwg A/R Hardcoat S.S. Batch: 0.00

160

Large Fab

Large Fab

Memo

0.00

Large Fab

A/R 2059B Hardcoat BATCH: 131289

170

QC10- Inspect visual per QSI004- ground welds	0.00
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170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O	0.00
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180

QC

Memo

0.00

Quality Control

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Page 4

Thursday, May 07, 2015 9:01:33 AM

Item ID: D3537-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearpad
 Start Date: 5/7/2015 Start Qty: 60.00 *60* Cust Item ID:
 Required Date: 5/7/2015 Req'd Qty: 60.00 *60* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00							
210									
Packaging	Memo	0.00							
Packaging	LOCATION : FP001								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

X60 d ell 1-10/5/25

MCS MAY 29 2015

MCS MAY 29 2015

Picklist Print

Thursday, May 07, 2015 9:01:37 AM

Page 1

Work Order ID: 132324

132324

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

318.7176

0.106

7

M304S16GA

DL 5/05/07

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT019

318.7176

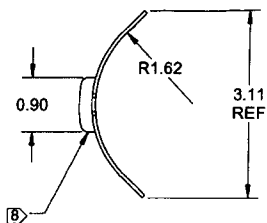
m131384

121.4176

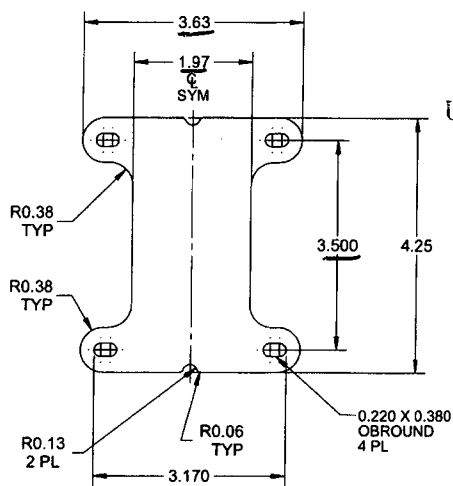
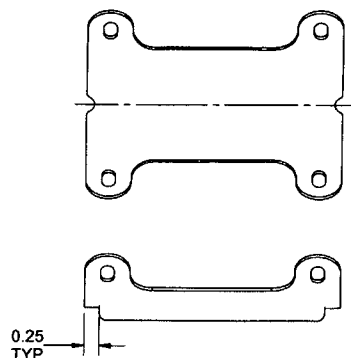
m131303

197.3

7.7



D3537-1 WEARPAD
(MAKE FROM D3537-1F)

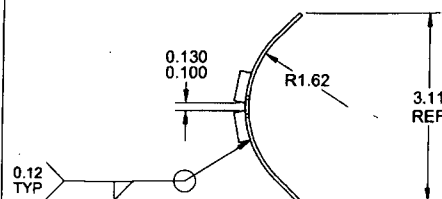


D3537-1F FLAT PATTERN

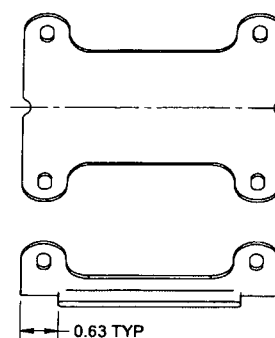
- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-1" PER QSI 044 6.1 (PERMANENT MARKER)
 - 7) WEIGHT: 0.42 lbs
 - 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
 - 9) WELDING: PER QSI 004

SHOP COPY
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UNCONTROLLED COPY
SUPERSEDED BY
WORK ORDER
NO. 132324.MC

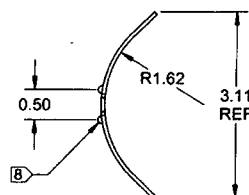
MAY 07 2015



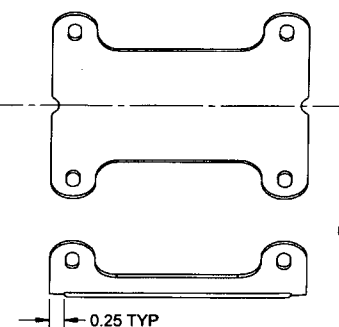
D3537-5 WEARPAD
(MAKE FROM D3537-1F)



- NOTES:**
- 1-5) AS PER D3537-1
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-5" PER QSI 044 6.1 (PERMANENT MARKER)
 - 7) WEIGHT: 0.42 lbs
 - 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
 - 9) WELDING: PER QSI 004



D3537-9 WEARPAD
(MAKE FROM D3537-1F)



- NOTES:**
- 1-5) AS PER D3537-1
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-9" PER QSI 044 6.1 (PERMANENT MARKER)
 - 7) WEIGHT: 0.19 lbs
 - 8) APPLY 2059B HARDCOAT WELD BEAD, 0.06 TO 0.13 THICK ON BOTTOM SURFACE, AFTER FORMING
 - 9) WELDING: PER QSI 004
 - 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

D	RE-FORMAT DRAWING, ADD -9/-11 WEARPADS	DB	14.10.16
C	WIDEN TAB TO 0.380, WELD PATTERN	CB	07.04.13
B	ADD AMS 5513 AND AMS 5524	CB	07.03.20
A	NEW ISSUE	CB	06.11.06

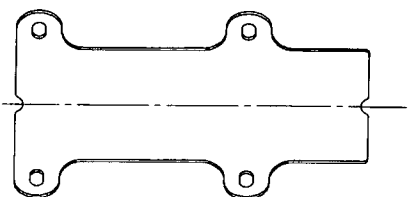
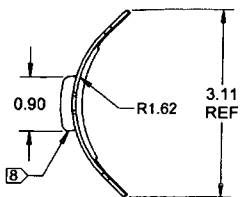
REV.	DESCRIPTION	BY	DATE
DESIGN	CB		
DRAWN	DB		
CHECKED	DW		
MFG. APPR.	DD		
APPROVED	MP		
DE APPR.	DS		
DATE	14.10.16		

DART AEROSPACE USA, INC.
KENT, WA

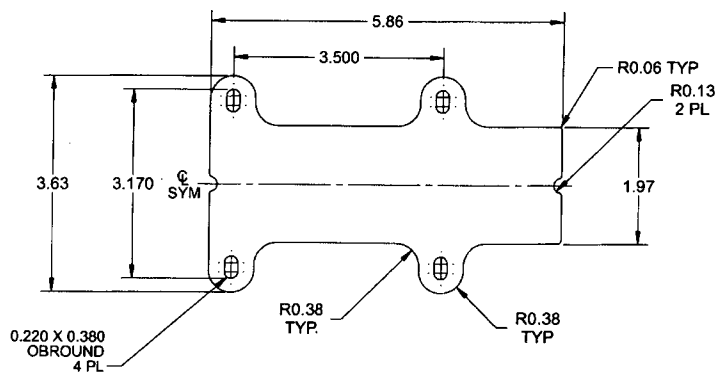
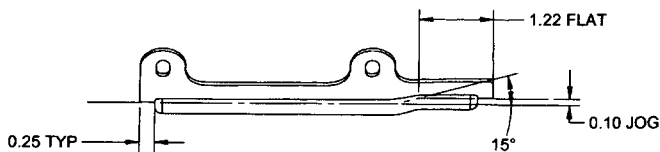
DRAWING NO. **D3537** REV. D
SHEET 1 OF 2
TITLE **WEARPAD** SCALE NTS

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2014-11-05



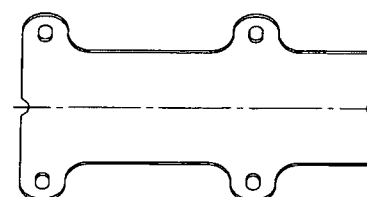
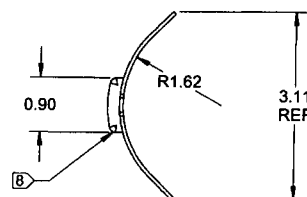
D3537-3 WEARPAD
(MAKE FROM D3537-3F)



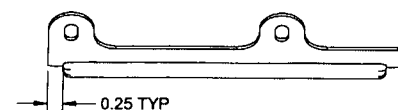
D3537-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-3" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.50 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004

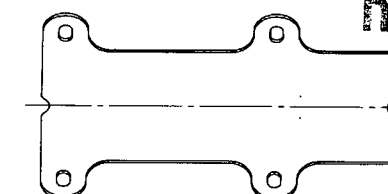
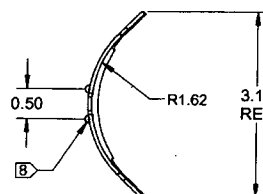


D3537-7 WEARPAD
(MAKE FROM D3537-3F)



NOTES:

- 1-5) AS PER D3537-3
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-7" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.50 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004



D3537-11 WEARPAD
(MAKE FROM D3537-3F)

NOTES:

- 1-5) AS PER D3537-3
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-11" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.25 lbs
- 8) APPLY 2059B HARDCOAT WELD BEAD, 0.06 TO 0.13 THICK ON BOTTOM SURFACE, AFTER FORMING
- 9) WELDING: PER QSI 004
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

APPROVED

DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. D
MFG. APPR.	DD	D3537	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WEARPAD	NTS
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